

20-8741



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.8511

Job Sheet 206035



Part No: 647.8511

Job Qty: 11 pcs

Part Name: Insert



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 1/31/20

Description:

Type: Stock

Note: DWG REV N/C IPP REV:A NEW ISSUE 16-11-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
100	Doosan - 1	11 pcs	1/31/20	1/31/20	1.00	8.76	Doosan - 1	<i>DC</i>
110	QC 2	11 pcs	1/31/20	0.00	0.00		QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	<i>QC 2-22 DC</i>
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S249783



Part: 647.8511

Job No: 206035

Serial No/Batch: S249783

Revision: Rev NC

Inspector:

Exp Date:

Instructions:

Date: 01/23/20

120 QC 8	11 pcs	1/31/20	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	M/D MK 20/01/23
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
122 Outsource - 17 - Passivate	11 pcs	1/31/20		GRO002-VC	7 JAN 2020-01-23
123 Packaging 2-1 - Receive - B4B	11 pcs	1/31/20	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	

					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
124 QC 6	11 pcs	1/31/20	0.00 0.00		QC 6 - 9	DAS
					QC 6 - 68	JAN 29 2020 68
					QC 6 - 61	9-89
					QC 6 - 40	
					QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	11 pcs	1/31/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	DAS
					Packaging 3 - 22 - B4B	84
					Packaging 3 - 23 - B4B	9-89
					Packaging 3 - 24 - B4B	CCX 116
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
140 QC 21 - SA	11 pcs	1/31/20	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	84
Part Op 100 - (Doosan Lathe) 1-Turn as per Folio FB511 & Dwg 647.8500 Folio Rev: N/A Dwg Rev: N/C 2-Deburr						
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)						
120 - (QC8- Inspect parts - second check)						

122 - Issue P/O to Groupe Altech: P/O 45670 -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required

123 - (Receive & Inspect for Damage & Mat'l Certs)

124 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA001

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.625 11304	303 Round Bar 0.625"	.4400 ft (.04 ea) 520	100-Doosan - 1	S/9.5.0/9

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R0.625 DAS 35 9-89 M304R0.625 (Pls. see e-mail attached)	0	32	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Insert	0.016Inches ± 0.005	0.021 0.011		
2	Insert	45.000Degrees ± 0.500	45.500 44.500	Angle	
3	Insert	0.020Inches ± 0.010	0.030 0.010	Radius	
4	Insert	0.210Inches + 0.005 - 0.001	0.215 0.209	Diameter	
5	Insert	0.300Inches ± 0.010	0.310 0.290	Diameter	
6	Insert	0.350Inches ± 0.010	0.360 0.340	Diameter	
7	Insert	0.060Inches ± 0.005	0.065 0.055		
8	Insert	0.374Inches ± 0.005	0.379 0.369		
9	Insert	0.560Inches + 0.000 - 0.010	0.560 0.550		
10	Insert	0.367Inches ± 0.005	0.372 0.362		
11	Insert	0.097Inches ± 0.005	0.102 0.092	Diameter	
12	Insert	0.075Inches ± 0.005	0.080 0.070	Depth	

Plex 1/22/20 2:02 PM Dart.lajeunesse.marie

Jean Francois Sauve

From: Alex Quan
Sent: January-20-20 4:39 PM
To: Jean Francois Sauve; Tyler Cross
Subject: RE: 647.8511

Hello Jean,

I do not see an issue with using M304 for these inserts. They are acceptable.

Alex

From: Jean Francois Sauve
Sent: Monday, January 20, 2020 10:44 AM
To: Tyler Cross <tcross@dartaero.com>; Alex Quan <aquan@dartaero.com>
Subject: 647.8511

Hi Tyler / Alex,

We have made part 647.8511 out of M304 instead of M303, 10 parts are affected.

Are they acceptable?

Thank-you

JEAN-FRANÇOIS SAUVÉ
Production Engineering Coordinator

DART AEROSPACE
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1 800 556- 4166
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER

POHB045670



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045670

PO Date: 1/23/20

Due Date: 1/31/20

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

2020-01-24

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206035	647.8511	647.8500 Rev NC	Insert -Issue P/O to Groupe Altech -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed - X11		1/30/20	11 pcs	0 pcs	11 pcs	\$0.59/pcs	\$6.49
							JAN 28 2020					
	205011				Firmed - X30		1/31/20	30 pcs	0 pcs	30 pcs	\$0.59/pcs	\$17.70
Sub Total:								41	0	41		\$24.19
2	205010	647.8510	647.8500 Rev NC	Insert ISSUE PO -Passivate, MIL-S-5002 TYPE 6 AS PER DWG (MPP-172) - Certificate of Conformity is required	Firmed - X340		1/31/20	340 pcs	0 pcs	340 pcs	\$0.59/pcs	\$200.60
							JAN 28 2020					
3	205012	647.8512	647.8500 Rev NC	Insert -Issue P/O -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed - X80		1/31/20	20 pcs	0 pcs	20 pcs	\$0.62/pcs	\$12.40
							JAN 28 2020					
Grand Total:												\$237.19

Guérin



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PURCHASE ORDER

POHB045670



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/24/20 8:27 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(025715-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupepaltech.com

Bon de Livraison / Packing Slip

025715 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte COURTIER / ACC. No.	Bon de commande Client Customer Purchase Order No				
27-Jan-2020		Jigar Patel		POHB045670				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. Ordered	Exp. Shipped	Qté NC/ NC Qty	Qté Shipped	À venir/ Back Order
1	647.8511 Rev.NC	647.8500 PASSIVATION NITRIC #1/ DICHROMATE [PASSIVATION NITRIC #1/ DICHROMATE] PASSIVATE, MIL-S-5002 TYPE - 6 AS PER DWG	PASSIVATION CH	11	11	0	0	0
2	647.8511 Rev.NC	647.8500 PASSIVATION NITRIC #1/ DICHROMATE [PASSIVATION NITRIC #1/ DICHROMATE] PASSIVATE, MIL-S-5002 TYPE - 6 AS PER DWG	PASSIVATION CH	30	30	0	0	0
3	647.8510 Rev.NC	647.8500 PASSIVATION NITRIC #1/ DICHROMATE [PASSIVATION NITRIC #1/ DICHROMATE] PASSIVATE, MIL-S-5002 TYPE - 6 AS PER DWG (MPP-172)	PASSIVATION CH	340	340	0	0	0
4	647.8512 Rev.NC	647.8500 PASSIVATION NITRIC #1/ DICHROMATE [PASSIVATION NITRIC #1/ DICHROMATE] PASSIVATE, MIL-S-5002 TYPE - 6 AS PER DWG (MPP-172)	PASSIVATION CH	20	20	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Entered: JK Date: DEC 07 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8741

Route update only ☐

Job: <u>201035</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>647.8511</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☒ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier Quality ☐
Date: <u>20/01/19</u>		Sequence #: <u>100</u>		QTY Affected: <u>11</u>		MRB (QSI042) DAS 9 9-89 <u>20-01-23</u>	
Description Work Order Deviation				Disposition		Completed By <u>JAN 23 2020</u> Lead hand / Supervisor <u>20/01/23</u> QC / QA Coordinator DAS 9 9-89 <u>20-01-23</u>	
made part out of H304 instead of H303				Acceptable one time only as per attach email.			
Root Cause ☒ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☒ Misread					
		Other/Details:					